

Date: Thursday, 10/18/2007 8:03:44 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 35218	
Estimate Number : 12740	
P.O. Number : <i>N/A</i>	Part Number : D353523
This Issue : 10/18/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 32735	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/5/2007 Qty: 30 Um: Each
Checked & Approved By : <i>[Signature] 07.10.18</i>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 1.4296 sf(s)/Unit Total : 42.8873 sf(s)  
 304/316 .040 Sheet

(M304S20GA)

Batch: *106027**B 07-10-25*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: *B*Prog Rev: *B**B 07-10-25**(30)*

2-Deburr if necessary

*B 07-10-25*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*counter*  
*5 07/10/30* *(430)*

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D3535 using Jig DT8158

3-Identify as D3535-23

*5B 07/10/31**(30)*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA:   D   Date:   8/11/05    
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:03:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35218

Part Number: D353523

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 A/0131 counter (30)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m 105042

BR 07-11-02 (30)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 07-11-02 (30)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-18

BR 07-11-02 (30)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

BR 07-11-05 (30)

Job Completion



CL0711105

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

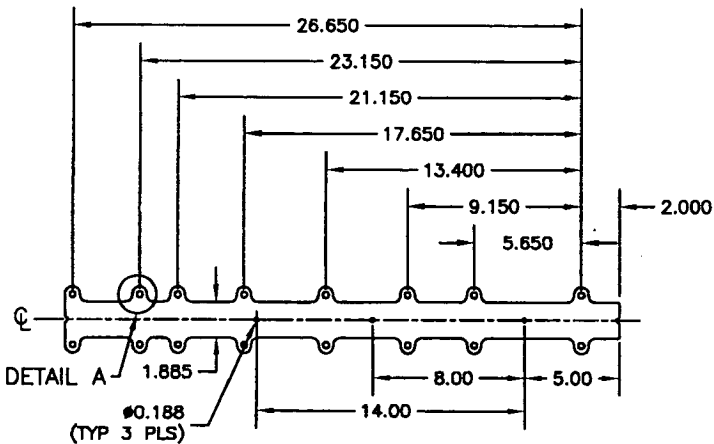
**NOTE:** Date & initial all entries

**DART**

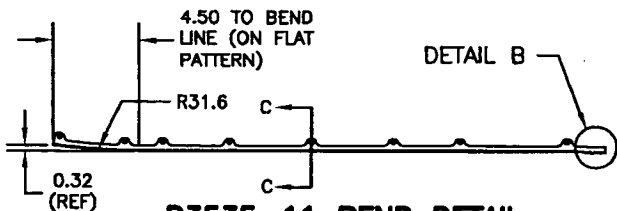
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07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 7
<i>[Signature]</i>	<i>[Signature]</i>	D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

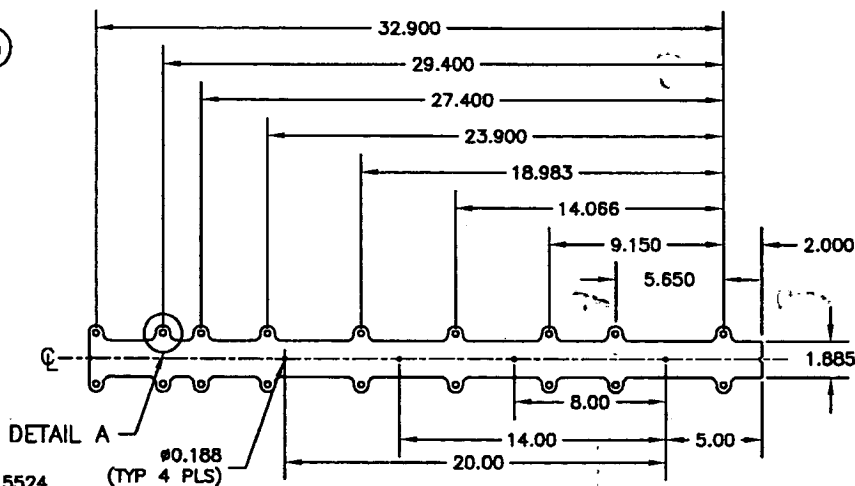


**D3535-11F FLAT PATTERN**

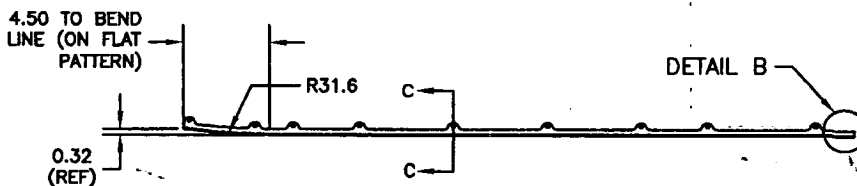


**D3535-11 BEND DETAIL**

SHOP COPY  
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WORK ORDER  
35218  
NO



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

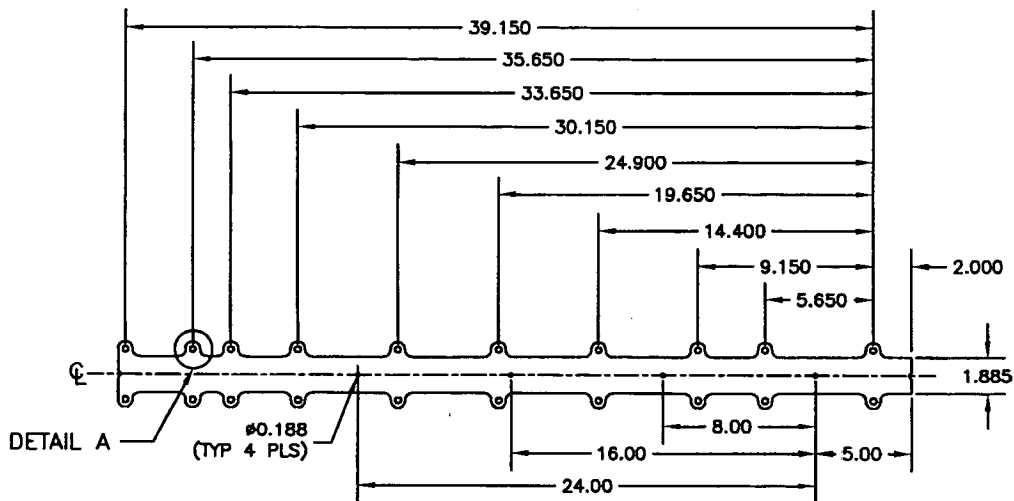
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- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

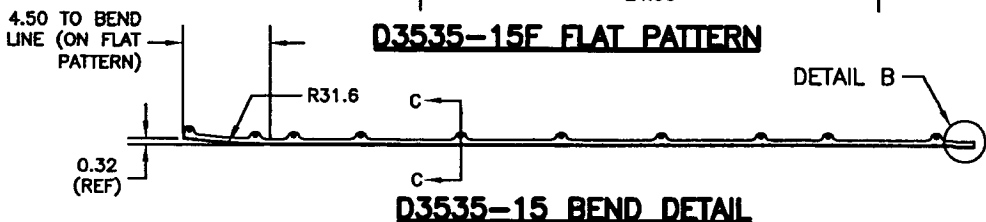
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07.04.24

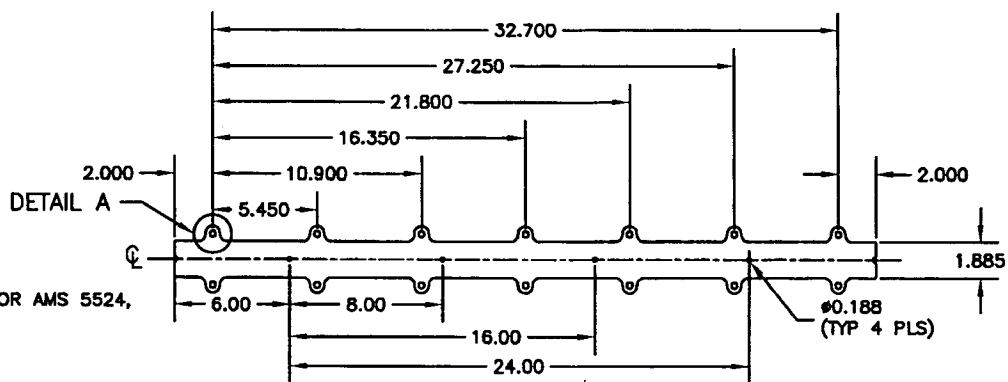
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CB	PH	PORT HADLOCK, WA	
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#	#	D3535	
DATE	TITLE	WEARSHOE	SCALE
07.04.17			1:10



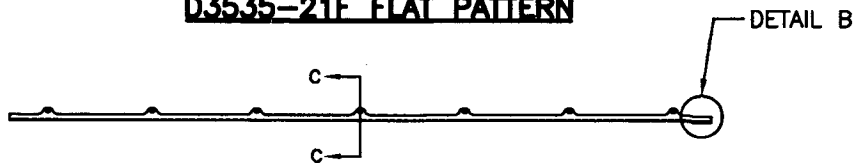
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

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NO. 5218

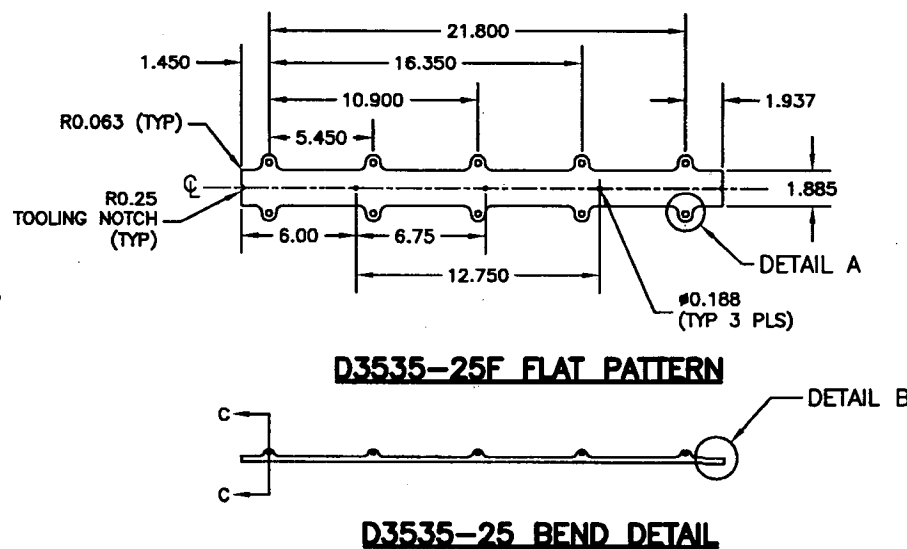
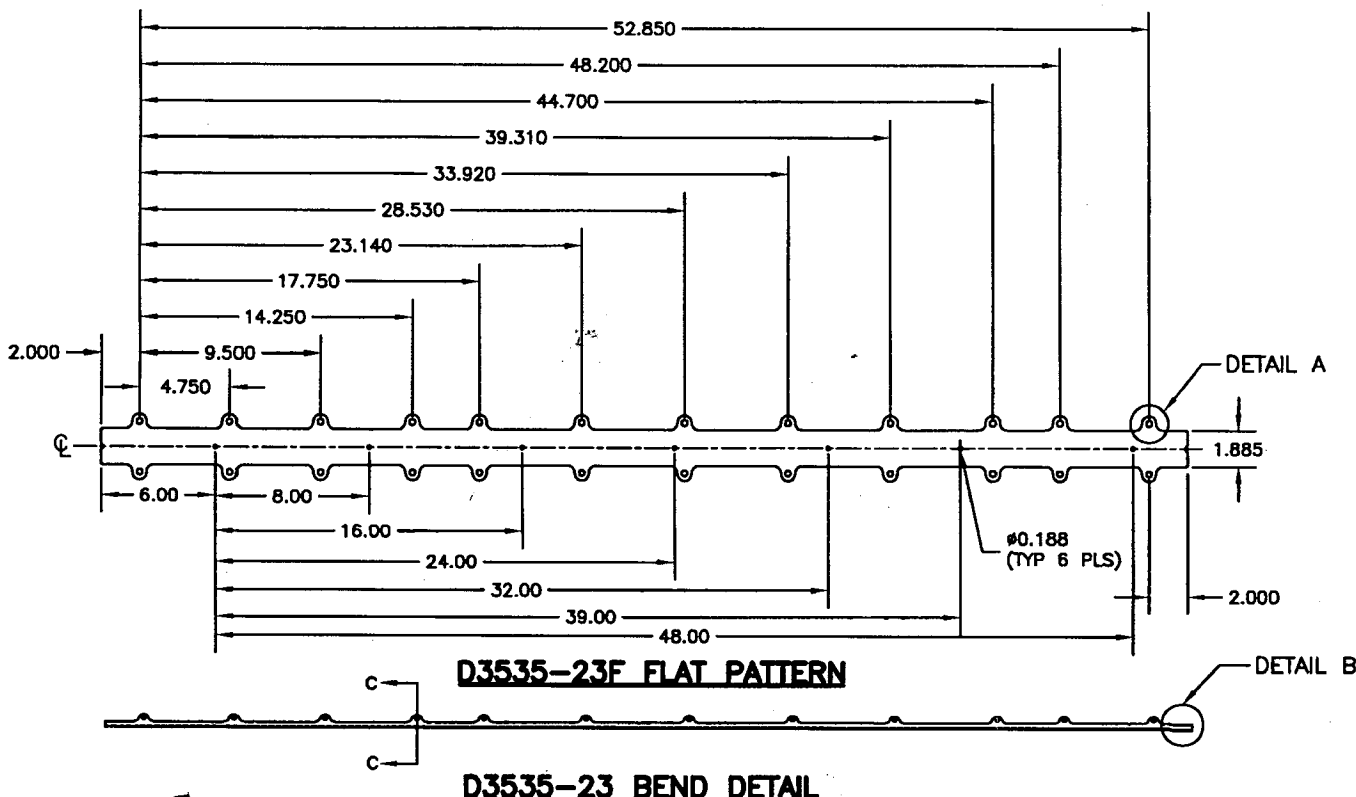
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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**DART**

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07.04.24



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**NOTES**

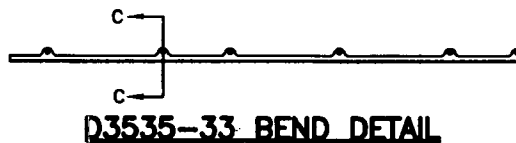
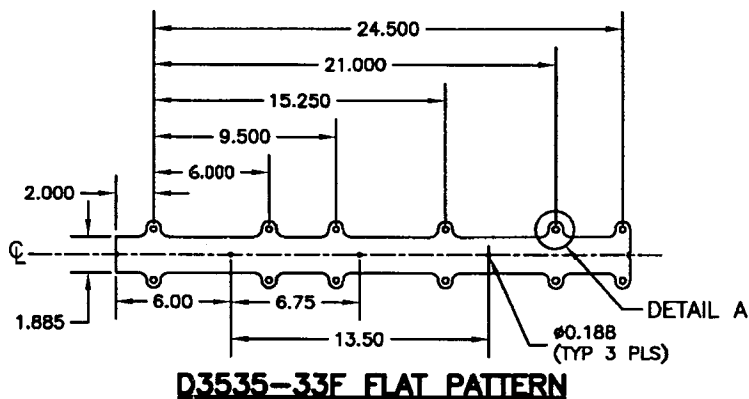
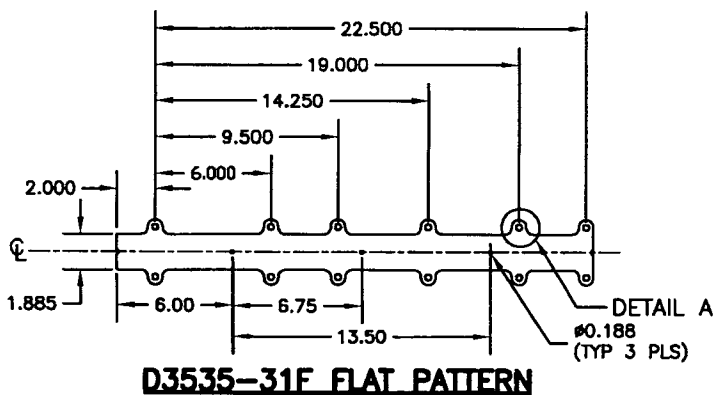
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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. B
CHECKED		APPROVED		PORT HADLOCK, WA	
DATE	07.04.17	TITLE	D3535	WEARSHOE	SHEET 3 OF 7
		SCALE	1:10		

**DART**

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07.04.17

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>	REV. B
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SHEET 4 OF 7	SCALE <b>1:10</b>



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**NOTES**

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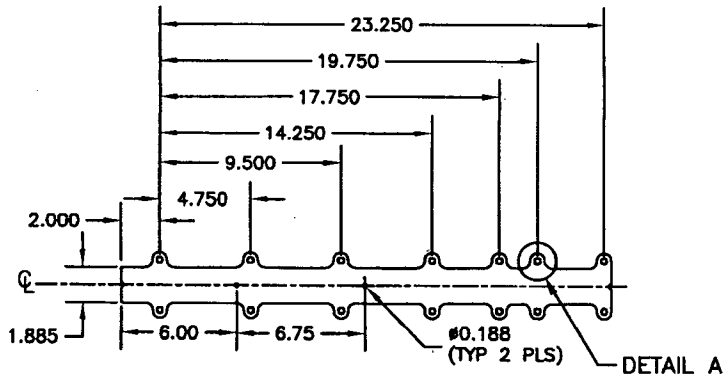


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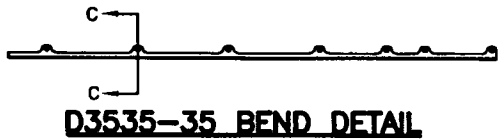
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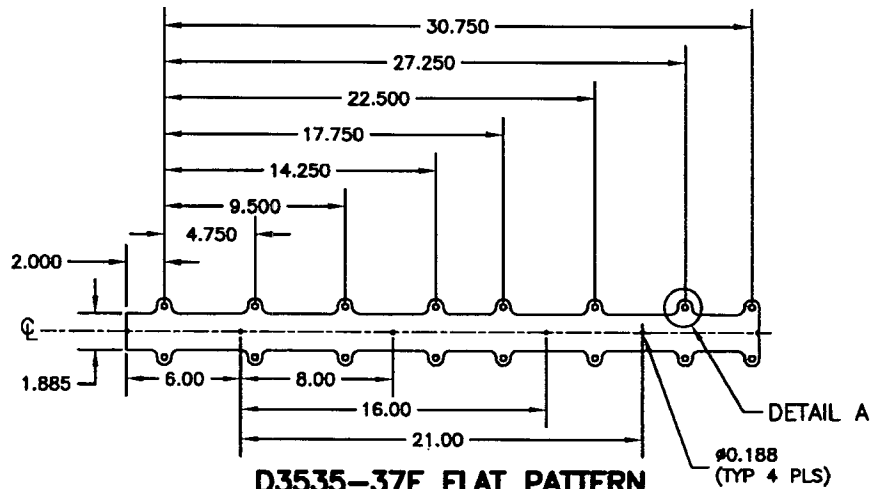
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 5 OF 7
		SCALE	1:10	



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

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NO. 35218

**NOTES**

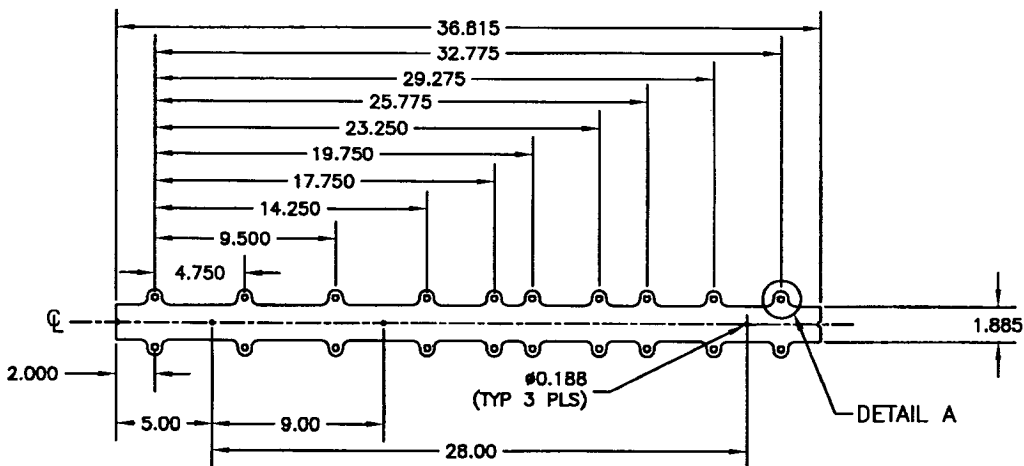
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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**DART**

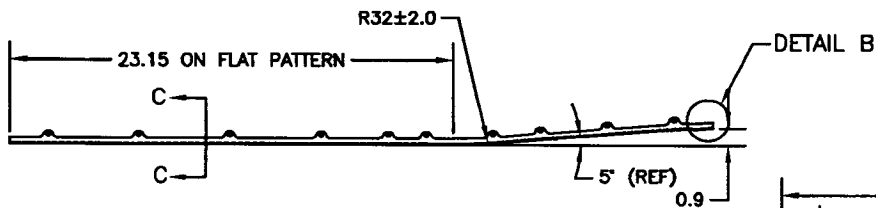
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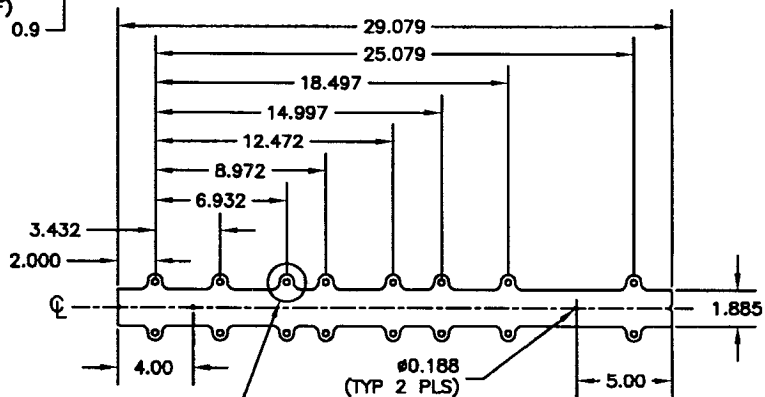
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SHEET 6 OF 7
07.04.17	WEARSHOE	SCALE
		1:10



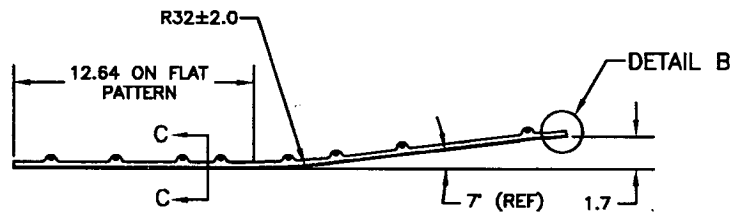
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

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NO. 35218

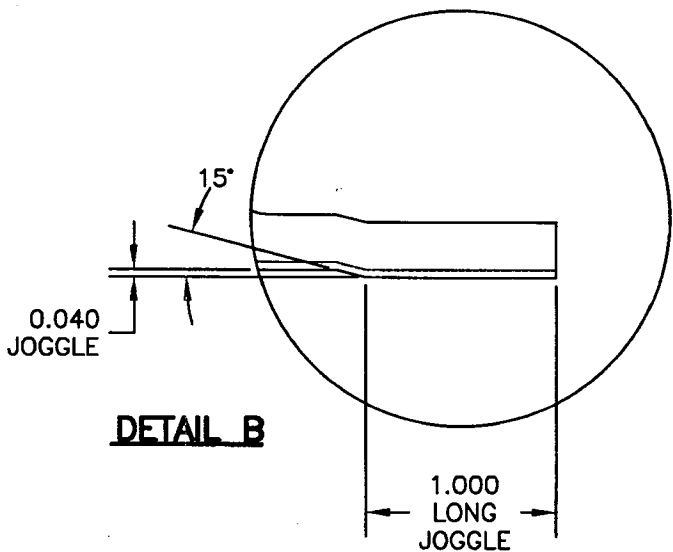
**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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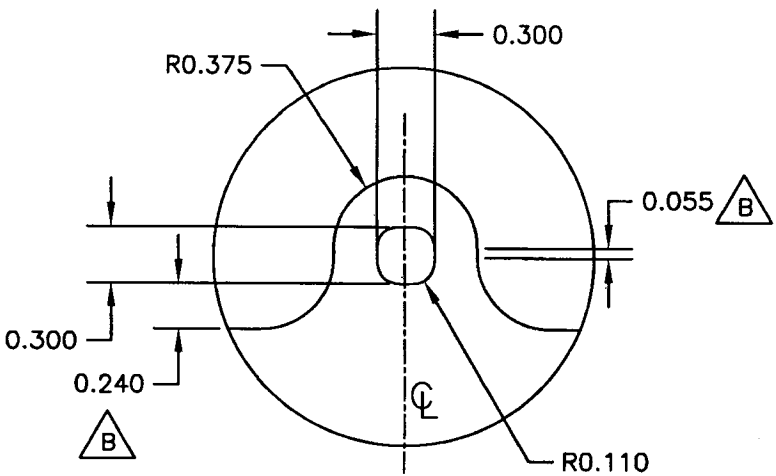


DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. B
CHECKED		APPROVED		PORT HADLOCK, WA	
DATE	07.04.17			DRAWING NO. D3535	SHEET 7 OF 7
				TITLE WEARSHOE	SCALE 1:1

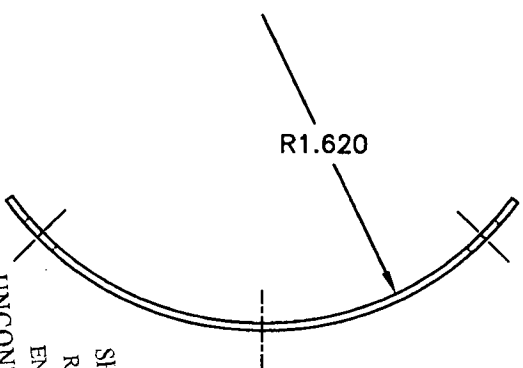
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07.04.24



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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WITHOUT NOTICE  
WORK ORDER  
NO 35218

DART AEROSPACE LTD		Work Order: 35218
Description: WEAR SHOE		Part Number: D3535-23
Inspection Dwg: 3535-23 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .188	+ .005 - .001	.188	*			
.300 X .300	+/- .010	.301 X .301	*			
6.00	+/- .030	6.00	*			
8.00	+/- .030	8.00	*			
16.00	+/- .030	16.00	*			
24.00	+/- .030	24.00	*			
32.00	+/- .030	32.00	*			
39.00	+/- .030	39.00	*			
48.00	+/- .030	48.00	*			
1.885	+/- .010	1.888	*			
2.000	+/- .010	2.000	*			
4.750	+/- .010	4.750	*			
9.500	+/- .010	9.500	*			
14.250	+/- .010	14.200	*			
17.750	+/- .010	17.750	*			
23.140	+/- .010	23.140	*			
28.530	+/- .010	28.530	*			
33.920	+/- .010	33.920	*			
39.310	+/- .010	39.310	*			
44.700	+/- .010	44.700	*			
48.200	+/- .010	48.200	*			
52.850	+/- .010	52.850	*			
2.00	+/- .030	2.00	*			

Measured by: RB	Audited by: En	Prototype Approval: u/
Date: 07-10-25	Date: 7/10/30	Date: 7

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	